

Thursday, 16/08/2007 11:32:04 AM  
Linda Lucelle

## Process Sheet

split 80 07/11/27

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 34017 - 1  
 Estimate Number : 11030  
 P.O. Number :  
 This Issue : 16/08/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : PURCHASED PARTS  
 Previous Run : 33589  
 Written By :  
 Checked & Approved By :  
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Drawing Name : BRACKET ASSEMBLY  
 Part Number : D2803042  
 Drawing Number : D2803 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 05/09/2007 Qty: 20 Um: Each

Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description :

1.0

D28032

STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

STA 84 BRACKET

Pick:

Qty Part Number Description  
 1 D2803-2 Bracket

Batch

B340327 1mx

mf. 07-11-27 ①

2.0

D28052

Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

STOP

Pick:

Qty Part Number Description  
 1 D2805-2 Stop

Batch

B 33600 1mx

mf. 07-11-27 ①

3.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty Part Number Description  
 1 D2809 Bushing

Batch

B 35631

mf. 07-11-27 ①

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34017

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation: Description:

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

mf 07-11-27 (1)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/27 (X)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105914

m-h 07/11/27

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W

07-11-27 (X)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

mf 07-11-27 (1)

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

m105426

mf 07-11-27 (1)

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

m105792

mf 07-11-27 (1)



Thursday, 16/08/2007 11:32:04 AM  
Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 34017

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	M105164

A/R	LPS-3	Corrosion Spray	M104929
-----	-------	-----------------	---------

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

MF 07-11-27

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D2803.

MF 07-11-27 ①

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MF 07-11-27 ②

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6A

MF 07-11-28 ③

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.28

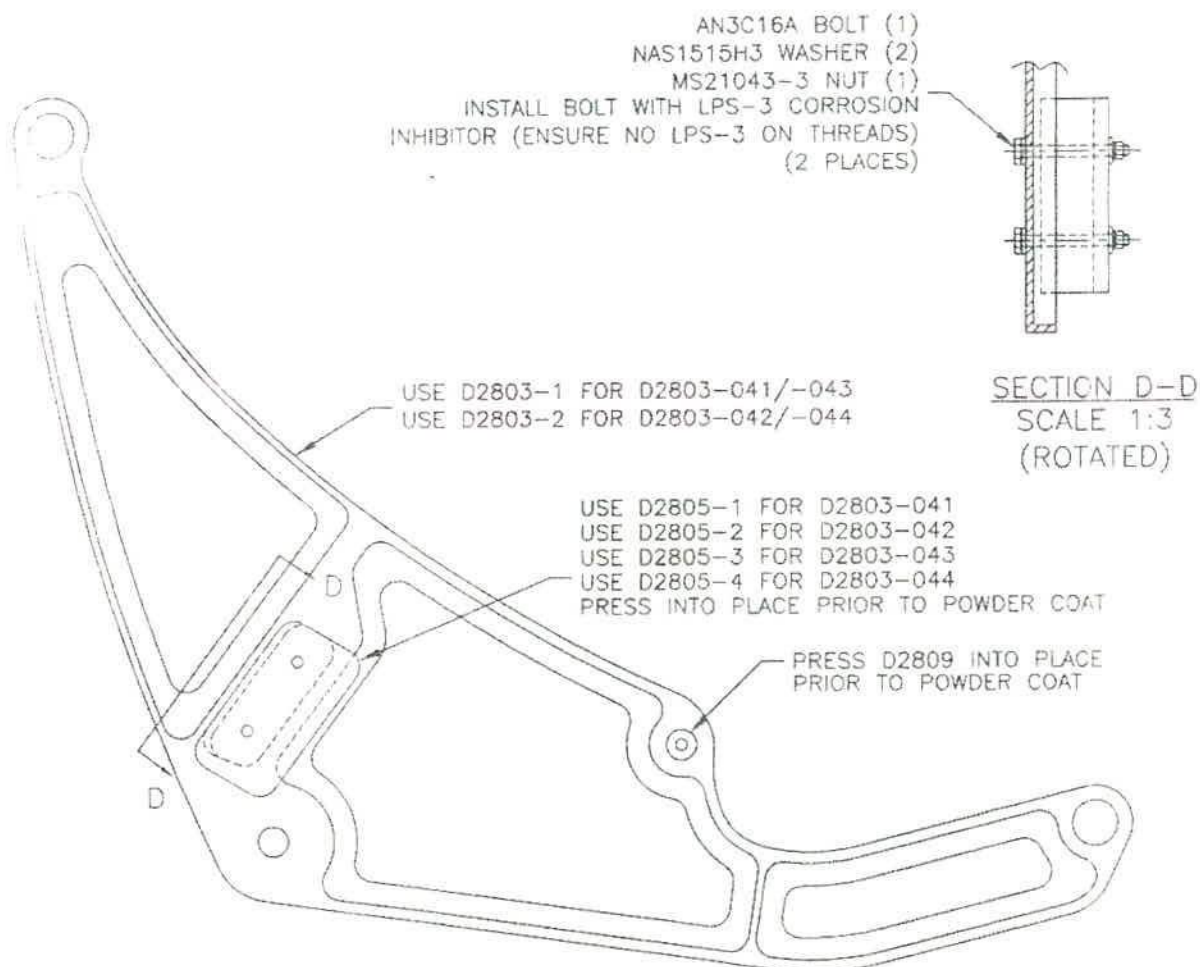
Job Completion



07.11.28



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



RELEASE

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.